

for flight test

Work Order ID 155064

155064

Page 1

Item ID: D5354-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: R66 Fwd Clamp Assembly, RH

Start Date: 01/06/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 01/18/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5354	B

100

0.01

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blanks at 4.250"

0.03

2

0

DAS
14
9-89

17/02/07

110

0.01

110

HAAS 5AXIS

HAAS CNC vertical machine #5

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB436 (D5354-2)

DWG REV: B

FOLIO REV: AA

0.11

2

0

DAS
14
9-89

17/01/08

2- deburr and break all sharp edge as per dwg

155064

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

2

2

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

**DAS
14
9-89**

2 k

Inspect on CMM as per folio CMMA039.
DWG REV: _____
CMM PROG. REV: _____

17/10/08

DAS
44
9-89

2

 ϕ

9-89 17-01-08

Issue P/O to ATG : _____

Black Anodize as per Dwg D5354

Certification of Conformity is required.

N/A *[Signature]* 17-01-06

Work Order ID 155064***155064***

Page 3

Item ID: D5354-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: R66 Fwd Clamp Assembly, RH

Start Date: 01/06/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 01/18/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

150

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.01

Certification of Conformity is required.

155

155

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.01

N/A
17 01.06

Work Order ID 155064***155064***

Page 4

Friday, January 06, 2017 10:55:25 AM

Item ID: D5354-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: R66 Fwd Clamp Assembly, RH
Start Date: 01/06/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 01/18/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.01

160

Small Fab

Small Fab

Memo

-Assemble as per dwg.

-Secure nuts as per dwg. (Note #8)

-Apply proseal as per dwg.

Batch: 136076Exp. date: 5/17

0.06

2FF

JAN 12 2017

170

0.00

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.01

2DAS
38
9-89

JAN 13 2017

Handwritten signature and date: 12-10-16-D1
Stamp: JAN 13 2017

POSITIVE RECALL**EFFECTIVE** 12-01-11 **AUTH** 9**RELEASED** _____ **DATE** _____DAS
9
9-89*flight test*

155064

Friday, January 06, 2017 10:55:25 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 01/06/2017 **Start Qty:** 2.00

2

Required Date: 01/18/2017 **Req'd Qty:** 2.00

2

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

180

180

Packaging

Packaging

Identify as per dwg & Stock Location:_____

0.00

Memo

0.00

190

*** 190 ***

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.03

Picklist Print

Page 1

Friday, January 06, 2017 10:55:24 AM

Work Order ID: 155064

155064

Parent Item: D5354-042

D5354-042

Parent Item Name: R66 Fwd Clamp Assembly, RH

Start Date: 01/06/2017

Required Date: 01/18/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV.A New issue 16/07/08 JFS Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B1.250X04.50
0

Purchased

No

100

f

11.7564

0.354

0.745263

DAS
14
9-89

M6061T6B1 250X04 500

6061-T6 Bar 1.25 X 4.50

**

Location

Loc Qty

Loc Code

MAT004

11.7564

m133038

0.3014

m134776

11.455

1.75

17/01/07

D5316-1

Manufactured

No

160

Each

1.0000

1

2

DAS
30
9-89

D5316-1

T-Bolt Strap

**

Location

Loc Qty

Loc Code

ST163

1

152000

1

B155066
155235

①

1 ← NOT Pulled

FF
JAN 12 2017

D5351-1

Manufactured

No

160

Each

5.0000

2

4

DAS
30
9-89

D5351-1

T-Bolt Spacer

**

Location

Loc Qty

Loc Code

prelim

5

140611

5

B 155070

④

Picklist Print

Friday, January 06, 2017 10:55:24 AM

Work Order ID: 155064

Parent Item: D5354-042

Parent Item Name: R66 Fwd Clamp Assembly, RH

155064

D5354-042

Start Date: 01/06/2017

Required Date: 01/18/2017

Start Qty: 2.00

Required Qty: 2.00

MS21043-3	Purchased	No	160	Each	1,352.000	2	4	DAS 30 9-89	JAN 12 2017
**									

MS21043-3

Nut

Location	Loc Qty	Loc Code
CCK007	361	
m135864	361	
FG	80	
103691	80	
FP001	403	
m130673	11	
m136182	392	
GA	39	
m133990	39	
ST302	400	
m136295	400	4
ST304	69	
m131340	69	

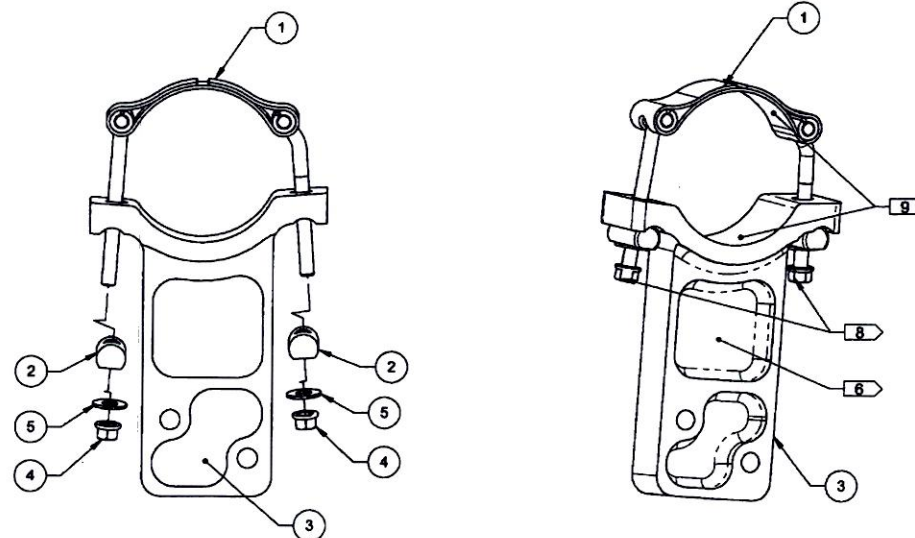
NAS1149D0332J	Purchased	No	160	Each	1,481.000	2	4	DAS 30 9-89	JAN 12 2017
**									

NAS1149D0332.J

Washer

Location	Loc Qty	Loc Code
FP001	92	
m134848	92	
GA	146	
m134848	146	4
ST260a	1200	
m136015	1200	
ST264	43	
m135672	43	

ITEM	QTY	P/N	DESCRIPTION
	X	D5354-041	R66 FWD CLAMP ASSY, LH
1	1	D5316-1	T-BOLT STRAP
2	2	D5351-1	T-BOLT SPACER
3	1	D5354-1	SUPPORT, LH
4	2	MS21043-3	NUT, SELF-LOCKING
5	2	NAS1149D0332J	WASHER
6	A/R	PROSEAL 890	SEALANT



D5354-041 R66 FWD CLAMP ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.37 lbs
- 8) SECURE NUTS WITH 1-2 THREAD AS SHOWN
- 9) APPLY AN EVEN LAYER OF PROSEAL 890 (0.02" - 0.03" THICK) ON INSIDE SURFACE

RELEASED
2016-06-29
ECN 16-579

APPROVED

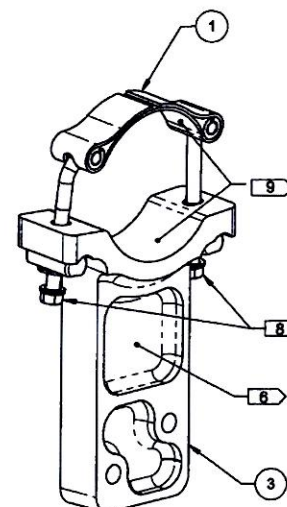
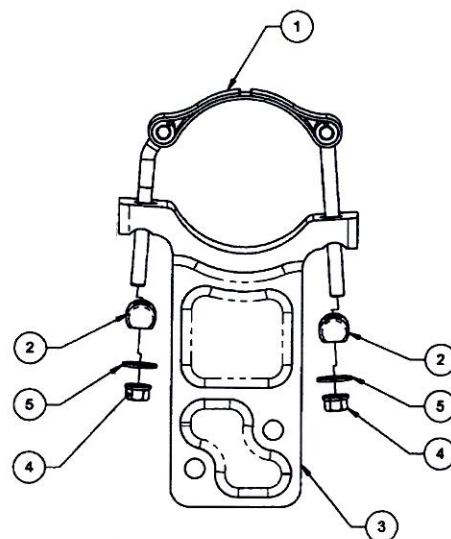
B	REDESIGN - 1/-041, ADD -2/-042, REMOVE -043 (ZN A5-1, A5-2, A5-3, A5-4); ADD NOTE 9 (ZN A5-1, A5-2)	RF	16.05.24
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	16.05.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5354** REV. B
SHEET 1 OF 4
SCALE NTS
R66 FWD CLAMP ASSEMBLY

COPYRIGHT © 2015 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

ITEM	QTY	P/N	DESCRIPTION
	X	D5354-042	R66 FWD CLAMP ASSY, RH
1	1	D5316-1	T-BOLT STRAP
2	2	D5351-1	T-BOLT SPACER
3	1	D5354-2	SUPPORT, RH
4	2	MS21043-3	NUT, SELF-LOCKING
5	2	NAS1149D0332J	WASHER
6	A/R	PROSEAL 890	SEALANT



D5354-042 R66 FWD CLAMP ASSY, RH

NOTES:

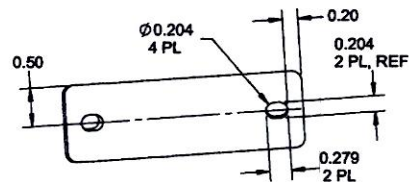
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.37 lbs
- 8) SECURE NUTS WITH 1-2 THREAD AS SHOWN
- 9) APPLY AN EVEN LAYER OF PROSEAL 890 (0.02" - 0.03" THICK) ON INSIDE SURFACE

APPLY AN EVEN LAYER OF PROSEAL 890 (0.02" - 0.03" THICK) ON INSIDE SURFACE

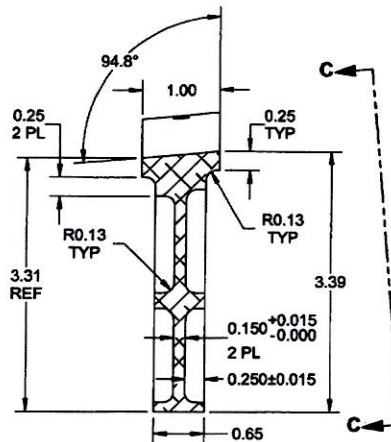
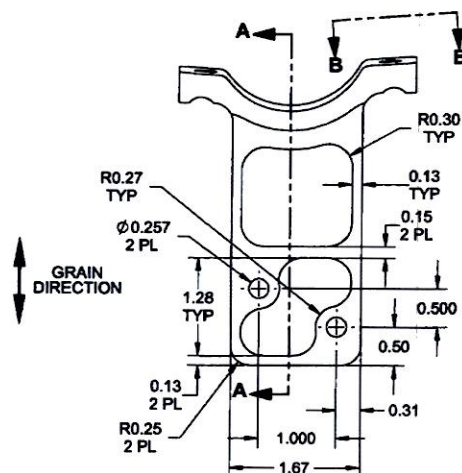
RELEASED
2016-06-29

APPROVED
Ch

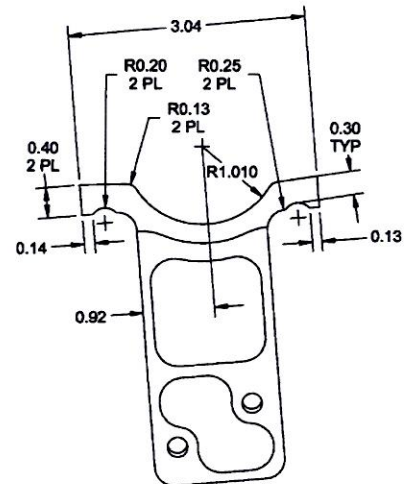
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5354	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS-#	R66 FWD CLAMP ASSEMBLY	NTS
DATE	16.05.24	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



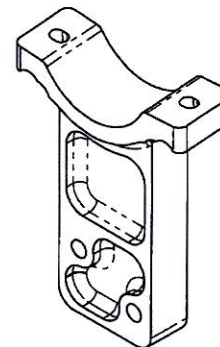
**VIEW B-B
(TYPICAL)**



SECTION A-A



VIEW C-C



D5354-1 SUPPORT, LH

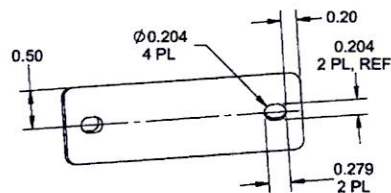
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs
- 8) UNDEFINED FEATURES CONTROLLED BY CAD FILE D5354-1 Rev. B.SLDPR

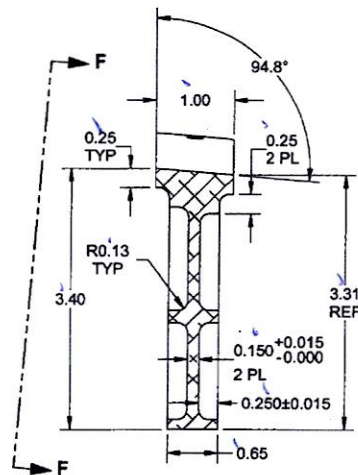
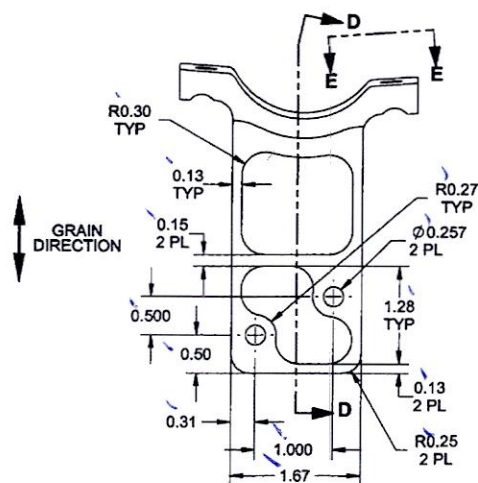
RELEASED
2016-06-29

APPROVED

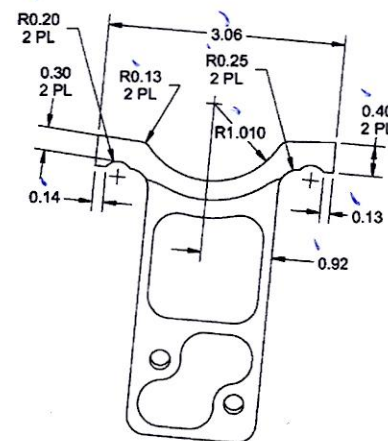
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5354	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 FWD CLAMP ASSEMBLY	NTS
DATE	16.05.24	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



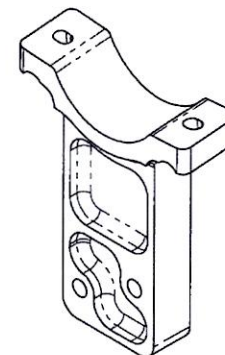
VIEW E-E
(TYPICAL)



SECTION D-D



VIEW F-F



B D5354-2 SUPPORT, RH

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs
- 8) UNDEFINED FEATURES CONTROLLED BY CAD FILE D5354-2 Rev. B.SLDPRT

RELEASED
2016-06-29

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO. D5354	REV. B
MFG. APPR.	JFS		SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 FWD CLAMP ASSEMBLY	NTS
DATE	16.05.24	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 155064
Description: SUPPORT, RH		Part Number: D5354-2
Inspection Dwg: D5354 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.50	±.030	.500	—		Vern M-06	
Ø.204	±.005	.206	—		"	
.20	±.030	.188	—		"	
.279	±.010	.278	—		"	
Ø.257	±.005	Ø.260	—		"	
1.28	±.030	1.277	—		"	
.13	±.030	.123	—		"	
R.25	±.030	R.250	—		R-6	
1.000	±.005	1.000	—		Vern M-06	
1.67	±.030	1.670	—		"	
.31	±.030	.307	—		"	
.50	±.030	.499	—		"	
.500	±.005	.500	—		"	
.15	±.030	.140	—		"	
.13	±.030	.123	—		"	
3.40	±.030	3.395	—		"	
R.13	±.030	R.125	—		R-6	
.25	±.030	.240	—		Vern M-06	
1.00	±.030	1.000	—		"	
94.8°	±1/2°	94.5°	—		C-Square	
.25	±.030	.250	—		Vern M-06	
.150	±.005	.158	—		"	
.250	±.015	.250	—		"	
.65	±.030	.653	—		"	
R.20	±.030	R.200	—		R-6	
R.13	±.030	R.125	—		"	
R.25	±.030	R.250	—		"	
3.06	±.030	3.056	—		Vern M-06	
.40	±.030	.395	—		"	
.13	±.030	.132	—		"	
.14	±.030	.140	—		"	
.30	±.030	.303	—		"	

Measured by: 14 9-89	Checked by: 44 9-89	QC Inspector:
Date: 17/07/08	Date: 17-01-09.	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	